



AEROSPACE MATERIAL SPECIFICATION

AMS4775™**REV. K**

Issued 1952-11
Reaffirmed 2000-08
Revised 2018-08

Superseding AMS4775J

Nickel Alloy, Brazing Filler Metal
73Ni - 0.75C - 4.5Si - 14Cr - 3.1B - 4.5Fe
1790 °F (977 °C) Solidus to 1970 °F (1077 °C) Liquidus
(Composition similar to UNS N99600)

RATIONALE

AMS4775K incorporates industry standard requirements of AWS A5.8, revises Title, Burn-off of Binder (3.3.1.1, 3.3.2.2) Powder mesh designations (3.5.1.1), Sampling and Testing (4.3.2.1), and Reports (4.4), prohibits unauthorized exceptions (3.6), and is a Five-Year Review and update of this specification.

1. SCOPE

1.1 Form

This specification covers a nickel alloy in the form of wire, rod, strip, foil, and powder and a viscous mixture (paste) of the powder in a suitable binder.

1.2 Application

This filler metal has been used typically for joining corrosion and heat-resistant steels and alloys requiring corrosion and oxidation resistant joints with good strength at elevated temperatures, but usage is not limited to such applications. Also may be used as a corrosion and oxidation resistant hard coating.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), or www.sae.org.

ARP1917 Clarification of Terms Used in Aerospace Metals Specifications

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2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM E18 Rockwell Hardness of Metallic Materials

ASTM E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness

2.3 AWS Publications

Available from American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33166-6672, Tel: 1-800-443-9353 or 305-443-9353, www.aws.org.

AWS A5.01 Welding Consumables - Procurement of Filler Metals and Fluxes

AWS A5.8 Specification for Filler Metals for Brazing and Braze Welding

3. TECHNICAL REQUIREMENTS

3.1 Product shall meet the requirements of AWS A5.8 BNi-1 and the following:

3.2 Condition

The product shall be supplied in the following condition:

3.2.1 Wire and Strip

Powder bonded in a suitable binder.

3.2.2 Rod

As cast, with fins and projections removed.

3.2.3 Foil and Powder

As fabricated.

3.2.4 Paste

Shall consist of 84 to 90% by weight powder in a suitable binder and, unless otherwise ordered, shall not contain flux.

3.3 Properties

Filler metal shall conform to the following requirements:

3.3.1 Wire and Strip

3.3.1.1 Burn-Off of Binder

Organic binder used for bonding powder to form wire and strip shall be fully burnt off, leaving no adherent residue, when the product is heated to a temperature of 1000 °F (538 °C) in an inert or reducing atmosphere, or vacuum (10^{-3} torr or better).

3.3.2 Paste

3.3.2.1 Paste shall have a shelf life of not less than 6 months; not more than thorough mixing shall be required to restore paste for use during that time.